

# Work Order ID 84798

**\*84798\***

Page 1

May-23-12 11:30:02 AM

Item ID: D3838-042

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop

**\*NS2\***

Start Date: 23/05/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/23

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3838	Rev A

100	Large Fab	0.00
-----	-----------	------

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: M 122130

5- c/sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: M 122130

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

SAD 12-11-08

CC 12-4-19 (3x)



**Work Order ID 84798****\*84798\***

Page 3

May-23-12 11:30:02 AM

Item ID: D3838-042

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 23/05/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 29/05/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/11/22 JJ

MRF  
12-11-21

# Picklist Print

May-23-12 11:30:05 AM

Page 1

Work Order ID: 84798

**\*84798\***

Parent Item: D3838-042

**\*D3838-042\***

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 23/05/2012

Required Date: 29/05/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	352.0000	1	3			

**\*D3759-1\***

Bushing

\*\*

CC 12-11-19

Location

Loc Qty

Loc Code

WA

202

B 89780 →

(3)

79213

1

83464

201

WA005

150

66489

1

82785

149

M304TS0.750W.065

Purchased

No

100

f

436.5616

1.0317

3.258

**\*M304TS0 750W 065\***

\*\*

SAD

12-11-08

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT017

384.1237042

120267

53.7325342

120633

330.39117

MAT018

45.78049

121170

4.78049

7636

41

WA007

0.5907428

116763

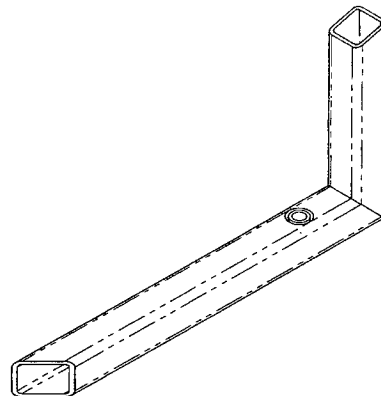
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WA035

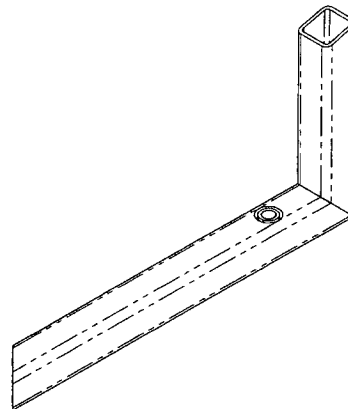
6.0667

118181

6.0667



**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 84798 MLJ  
12/05/23

**RELEASED**  
08/11/24

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

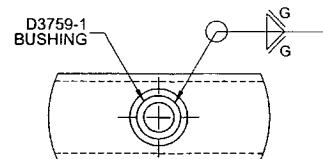
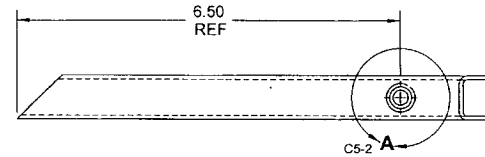
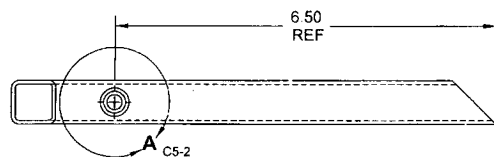
**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

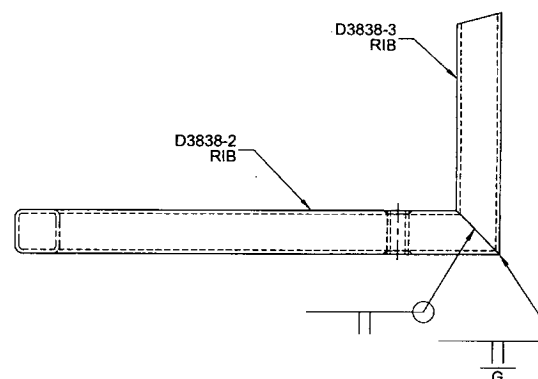
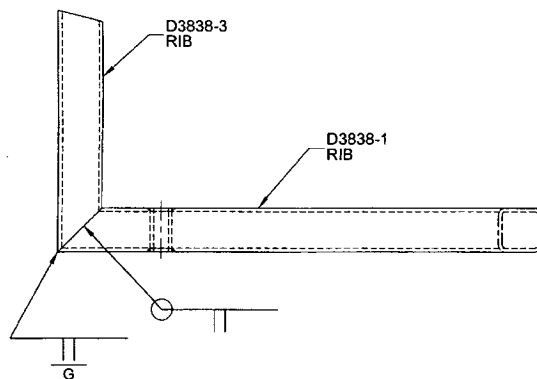
DRAWING NO. **D3838** REV. A  
SHEET 1 OF 3  
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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24798



**DETAIL A**  
D2-2  
D7-2 SCALE 2X

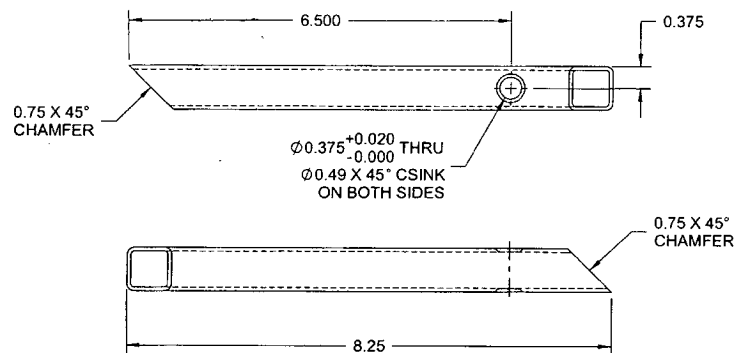


**D3838-041 RIB ASSY (BASKET LID, LH)**

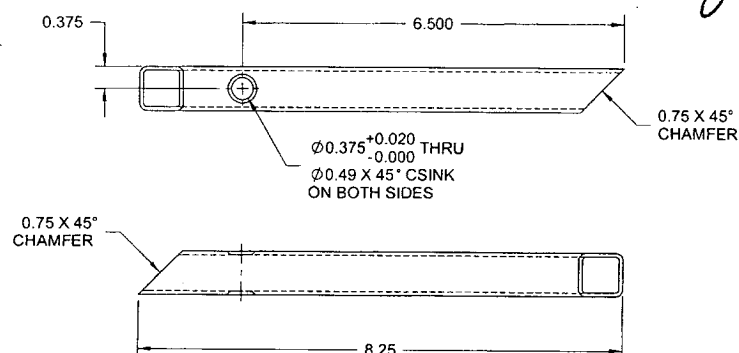
**D3838-042 RIB ASSY (BASKET LID, LH)**

**RELEASED**  
08/10/08

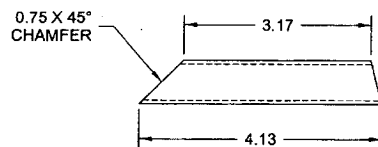
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		<b>RIB ASSY (BASKET LID)</b>	SCALE
DE APPR.			NTS
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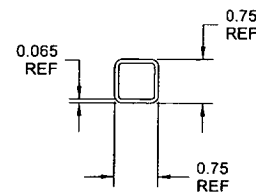
**D3838-1 RIB**



**D3838-2 RIB**



**D3838-3 RIB**



**TYPICAL SECTION  
VIEW**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

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DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3838	SHEET 3 OF 3
APPROVED			TITLE	SCALE
DE APPR.			RIB ASSY (BASKET LID)	NTS
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84798